



Dart Hawkesbury
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D4170-1
Job Sheet 168681



Part No: D4170-1

Job Qty: 20 ea

Part Name: ~~Bushing~~ *Spacer*



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 12/3/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD IPP Rev:A 10.11.02 as per revB DD
verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		12/2/17	0.00	0.00	Start Up Machining		<i>ULB</i>
100	Hardinge	20 pcs		12/2/17	0.00	0.58	Hardinge		<i>ULB</i>
120	QC	20 pcs		12/2/17	0.00	0.00	QC8		<i>W.P. 17/12/10</i>
125	Skidtubes	20 pcs		12/3/17	0.00	0.29	Skidtubes		<i>RLS</i>
130	Packaging	20 pcs		12/3/17	0.00	0.00	Packaging3		<i>BIC</i>
140	QC21-SA	20 Ea		12/3/17	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FA962

Descriptions: 125 - 1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

130 - ***STOCK IN SKIDTUBE CELL***

DAS
21
9-09

JAN 24 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6T0.375W.058	5	44	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	3.150Inches + 0.030 - 0.000	3.180 3.150		
2	Spacer	0.375Inches ± 0.010	0.385 0.365	Diameter	
3	Spacer	0.259Inches ± 0.010	0.269 0.249	Diameter	

Plex 11/21/17 8:08 AM dart.lacelle.linda



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Bushing

PART NO: D4170-1

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/08/17

Job No: 168681

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				